



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K8A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6521A00138-W142AH-3T-3
Job Sheet 198324


Part No: RBW6521A00138-W142AH-3T-3 **Job Qty:** 4 pcs
Part Name: Top Brace

Part Weight: 0 lbs **Status:** New **Priority:** Medium
Job Created: 7/25/19 **Job Tracking No:**
Due Date: 9/13/19 **Created By:** Marie Lajeunesse
Type: SOLD **Description:**
Note: DWG RBW6521A00138-W142AH-3T REV 5 IPP Rev. A 19.04.04 New issue DP Verify DD
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	NV5000 - 1	4 pcs	9/13/19		1.00	1.00	NV5000 - 1		Kt 19-08-12
							NV5000 - 2		
110	QC 2	4 pcs	9/13/19		0.00	0.00	QC 2 - 1		Kt 19-08-12
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		


Dart Aerospace Ltd.
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CANADA
TEL : 1 613 632 - 5200
Email: sales@dartaero.com
www.dartaerospace.com
Container No: S204894

Part: RBW6521A00138 - W142AH - 3T - 3
Job No: 198324
Serial No/Batch: S204894
Revision: 5
Inspector:
Exp Date:
Instructions:

Date: 08/12/19

120 QC 8	4 pcs	9/13/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	DAS 52 19/08/19
				QC 8 - 52	
				QC 8 - 23	9-89
				QC 8 - 57	
125 Outsource - 12 - Black Oxide	4 pcs	9/13/19		GRO002-VC	2019-08-15
126 Packaging 2-1 - Receive - B4B	4 pcs	9/13/19	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	AUG 22 2019
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
127 QC 6	4 pcs	9/13/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	DAS 40
				QC 6 - 40	AUG 22 2019 9-89
				QC 6 - 81	
130 Packaging 3-1 - Stock - B4B	4 pcs	9/13/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	DAS 28 9-89
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
140 QC 21 - SA	4 pcs	9/13/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	AUG 27 2019
				QC 21 - SA - 53	

Part Op 100 - 1-Machine as per folio FC 918 FOLIO REV: DA DWG REV: 5 2-Deburr
Descriptions: 110 - QC2- inspect parts off machine FAI/FAIB
120 - Engrave T/N and/or P/N using MARKTRONIC engraver as per DWG.
125 - Issue P/O; 44272 -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type;
4140 -Certificate of Conformity is required

- 126 - (Receive & Inspect for Damage & Mat'l Certs) C of C required.
- 127 - QC8- All purchased or subcontracted products
- 130 - Identify as per dwg & Stock Location:
- 140 - QC21- Final Inspection - Work Order Release

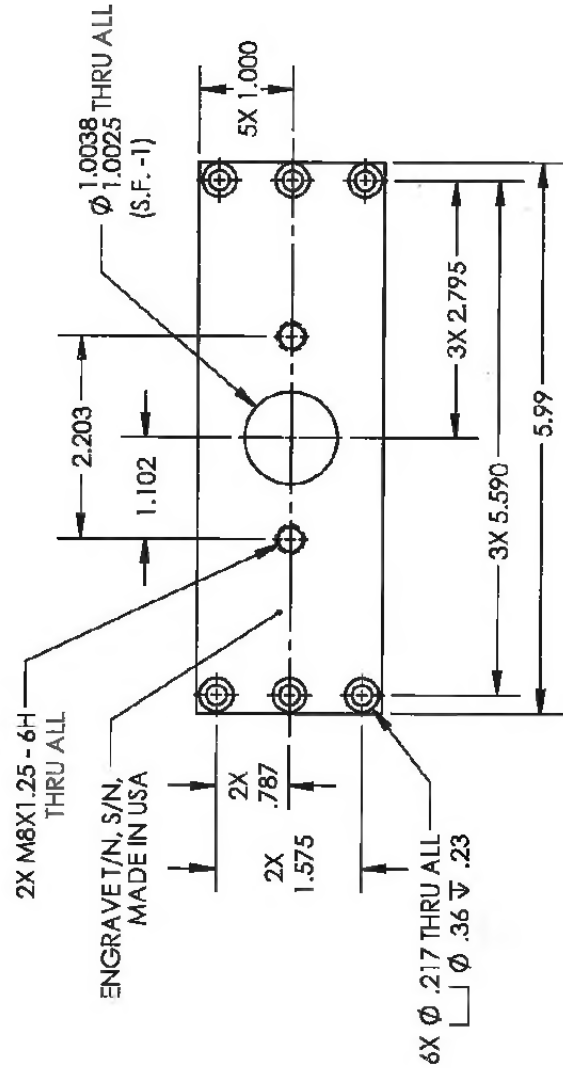
Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M1018B0.375x2.500	1010-4825 Steel Bar .375 x 2.500 MT-HRS-B-0.500 x 2.250	2 ft (S ea) .515"	100-NV5000 - 1	505 96 89
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-NV5000 - 1	M1018B0.375x2.500	2	13	0
Part Specifications				
Specifications could not be found.				

MAT
used
2.080

Plex 7/25/19 8:37 AM Dart.lajeunesse.marie

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
4	16-0123	-3 ADDED FINISH SPEC.	8/18/2016	DEW	JAG
5	16-0266	-3 CHD DIM WAS Ø1.0038/.0025 THRU ALL (S.F.-1).	12/6/2016	RJC	SM



DART
AEROSPACE

TITLE
NUT TORQUE TOOL

DWG NO.
RBW6521A00138-W142AH-3T-3

REV
5

MAT'L
1018/1020 GR

FINISH
BLACK OXIDE

SPEC
QMSI-8.2.2, B.O. REV D

DRAWN BY
PERRITT

CHECKED
CLOUGH

OPPS APPR
ANDERSON

QA APPR
LINDSAY

APPROVED
GILBERT

SCALE
1:2

DATE
12/31/2008

USED ON MODEL
AW139

SHEET 3 OF 8

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES
.XXX ± .005 FRACTIONS 2 IN
.XX ± .01 ANGLES 2.5°
.X ± .1 SURFACES = 12.5°
1. BREAK ALL SHARP EDGES
2. DIMENSIONAL LIMITS APPLY
3. INTERPRET DIM AND TOL PER
ASME Y14.5M-2009

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 198324 MLS
1707-25

③
TOP BRACE

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐ Skid-tube ☐ Machining ☐ Large Fab ☐				Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐					
Date :	Sequence #:	QTY Affected :		MRB (QS1042)									
Description Work Order Deviation				Disposition									
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors				FAULT CATEGORY Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details: Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread									
												Completed By	
												Lead hand / Supervisor	
												QC / QA Coordinator	



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PURCHASE ORDER
POHB044272



Supplier: GRO002-VC Group Altech 2455 Halpern St Laurent QC H4S 1N9 Canada Phone: 514-335-3666 Fax: 514-335-3668	PO No: POHB044272 PO Date: 8/15/19 Due Date: 8/23/19 Purchase Order Revision: Revision Date: Ship-To Contact: Guerin, Kimberley Phone: 613-632-5200 Ext: 298 kguerin@dartaero.com
Attention: Grenon, Sylvie	Via: Ground Pymt Terms: Net 60 Freight Terms: Special Comments:
Ship To: 1270 Aberdeen Street Hawkesbury ON K6A 1K7 Canada Phone: 613-632-5200	E-MAILED 2019-08-16

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	197183	RB6872882-1	Adjusting Screw -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/23/19	4 pcs	0 pcs	4 pcs	\$2.35/pcs	\$9.40

4 X AUG 22 2019

5199376



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PURCHASE ORDER
POHB044272



Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
2	196746	RBW109-3130-53-113-3	Pin -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-c- 81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	8/23/19	12 pcs	0 pcs	12 pcs	\$2.35/pcs	\$28.20
12 X AUG 22 2019 [Signature]											
5203982											
3	197461	RBE350A93-3317-20	Tail Rotor Hub Insert Tool -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/23/19	20 pcs	0 pcs	20 pcs	\$5.41/pcs	\$108.20
20 X AUG 22 2019 [Signature]											
5200134											
4	199087	RBE350A93-3303-02-3	Extractor -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/23/19	19 pcs	0 pcs	19 pcs	\$2.65/pcs	\$50.35



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Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	198324	RBW6521A00138-W142AH-3T-3	Top Brace -Issue P/O: -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	8/23/19	4 pcs	0 pcs	4 pcs	\$3.70/pcs	\$14.80
6	199075	RBST2120-15	Locating Pin -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/23/19	5 pcs	0 pcs	5 pcs	\$2.35/pcs	\$11.75
7	199077	RBST2120-9	Pin Outsource12 (Outside Processing - Black Oxide) Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	8/23/19	5 pcs	0 pcs	5 pcs	\$0.95/pcs	\$4.75

AS
10
-89

4 x AUG 22 2019

5204894

5 x AUG 22 2019

5205486

5 x AUG 22 2019

5205338



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Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	197189	RB6872882-9	Handle Weldment Outside Processing - Black Oxide -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL- PRF-16173 Grade 3 Class 1 or MIL-C- 81309 Type III Or MIL-C-23411A or MIL-PRF-81309 and wipe off excess. -Material type; 1018 -Certificate of Conformity is required	Firmed	-	8/23/19	3 pcs	0 pcs	3 pcs	\$0.95/pcs	\$2.85
3 X AUG 22 2019											
S 205327											

Grand Total: \$230.30

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/16/19 9:01 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(021617-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

021617- 1

Livré à / Ship to

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
Tel.: 613-832-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY, ON, K6A1K7
CANADA
BUYER:

Date expédition Ship date	Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
21-Aug-2019	Jigar Patel		POHB044272 ✓				
Ligne Line#	No. de Série / # Pièces Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Quantités / Quantities			
				Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/ Scrap/
1	RB6872882-1 Rev.	RB6872882-1 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS MAT TYPE; 4140	OXIDE-BLACK CH	4	4 ✓	0	0
2	RBW109-3130-53-113-3 Rev.	RBW109-3130-53-113-3 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS MAT TYPE; 4140	OXIDE-BLACK CH	12	12 ✓	0	0
3	RBE350A93-3317-20 Rev.	RBE350A93-3317-20 01-BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	20	20 ✓	0	0
5	RBW6521A00138-W142AH-3T-3 Rev.	RBW6521A00138-W142AH-3T-3 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS MAT TYPE; 4140	OXIDE-BLACK CH	4	4 ✓	0	0
6	RBST2120-15 Rev.	RBST2120-15 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	5	5 ✓	0	0
7	RBST2120-9 Rev.	RBST2120-9 BLACK OXIDE FINISH, MIL-C-13924C, CLASS 1	BLACK-OXIDE CH	5	5 ✓	0	0
8	RB6872882-9 Rev.	RB6872882-9 01-OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY A THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MILL-C23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS MAT TYPE; 1018	OXIDE-BLACK CH	3	3 ✓	0	0

RECEIVED

AUG 21 2019

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DAS
40
9-89



021617- 1

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HAWKESBURY, ON, K6A1K7
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BUYER:

Page 2 of 2